

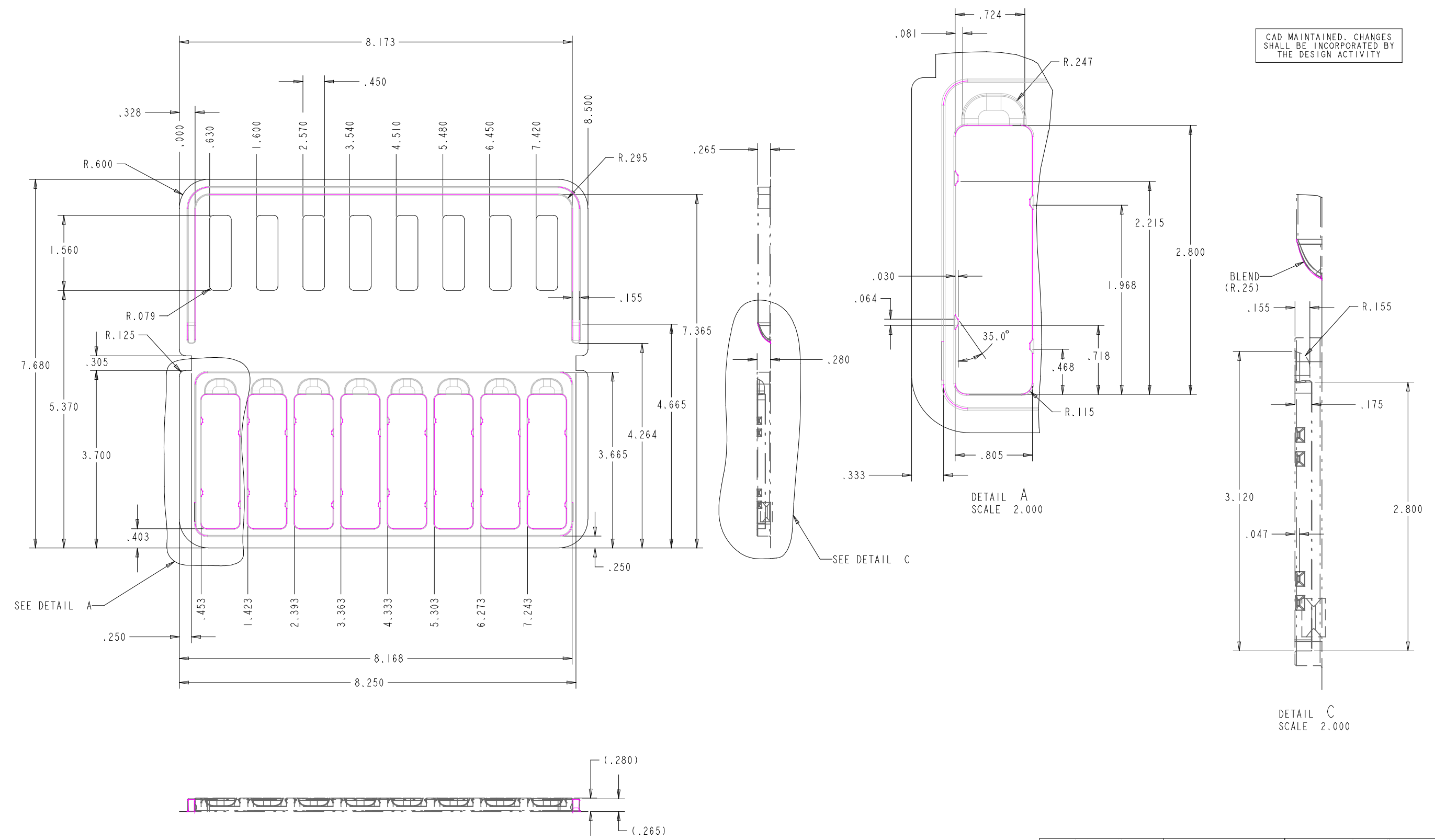
Operational/Training Panel Drawings and Specifications

Table of Contents:

1. Drawing HHA-0004- Single Assay Tray
2. Drawing HHA-JPO-10- Operational Panel Assembly
3. Operational/Training Panel Assembly Instructions
4. Special Packaging Instructions -PJPOHAA

| REVISIONS | | | |
|-----------|-------------|------|----------|
| LTR | DESCRIPTION | DATE | APPROVAL |

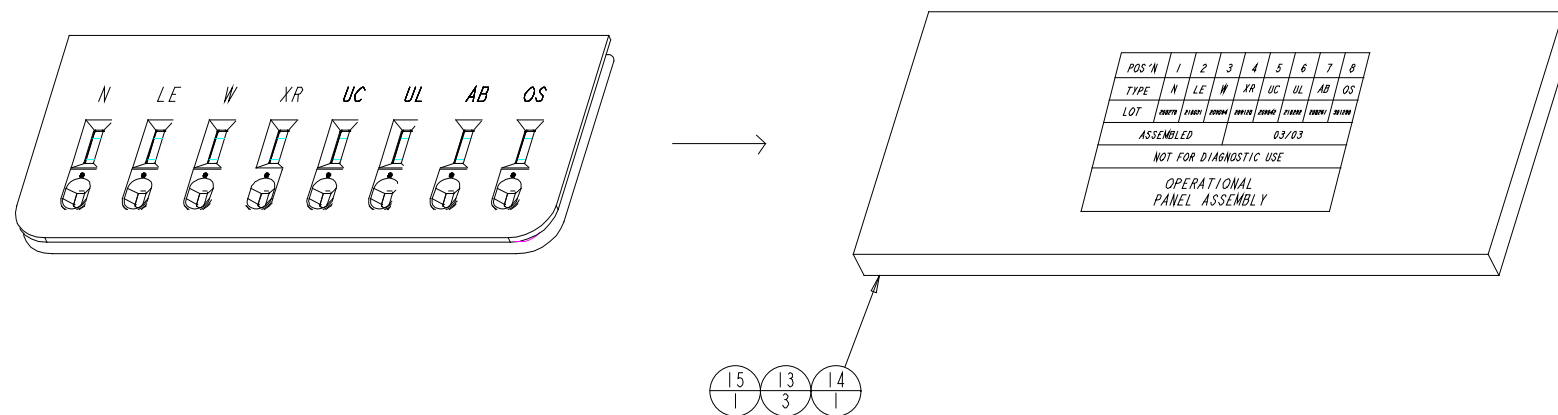
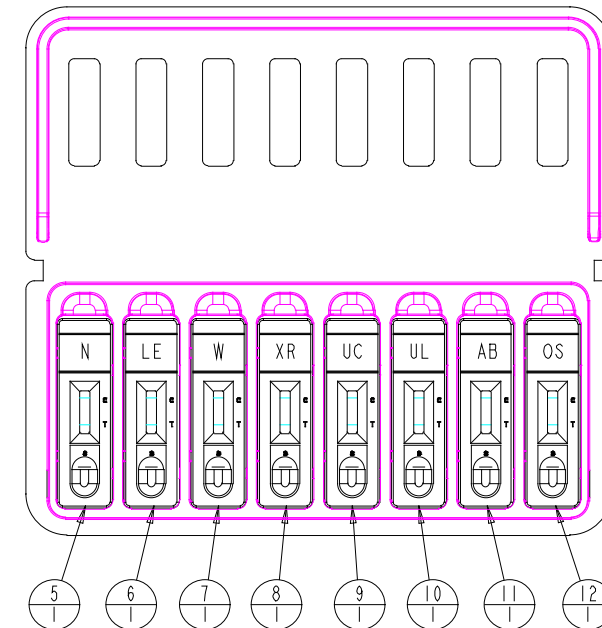
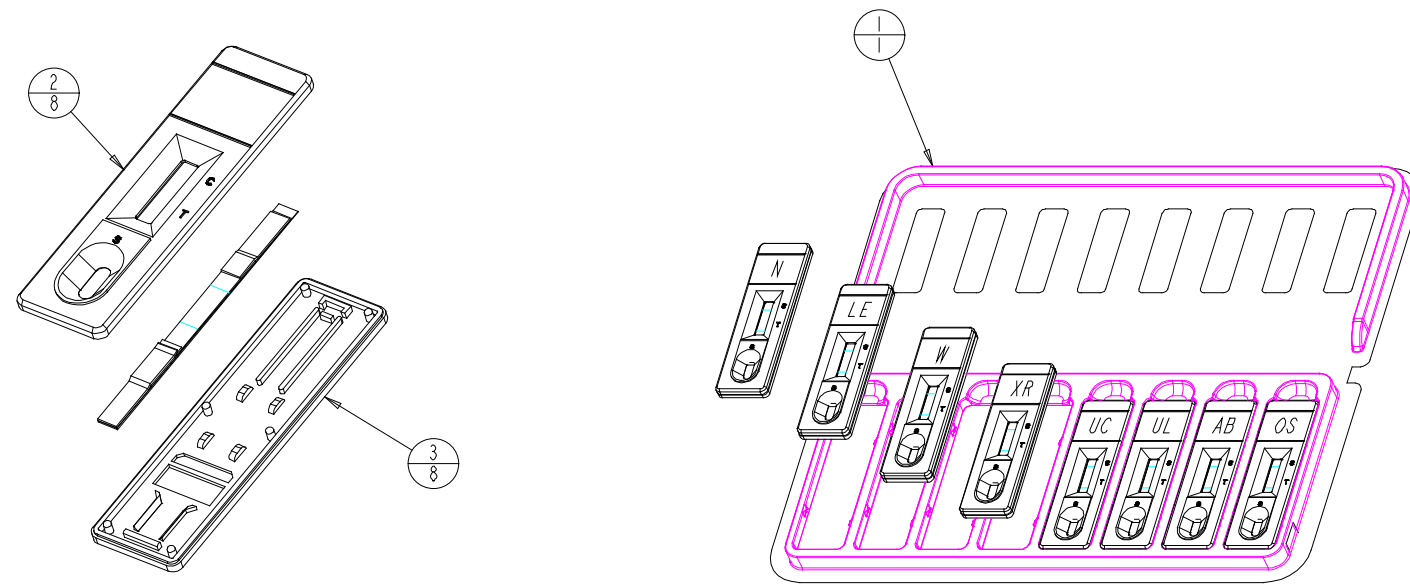
CAD MAINTAINED. CHANGES
SHALL BE INCORPORATED BY
THE DESIGN ACTIVITY



| | | | | | | | | | |
|---|------------------------|---|--|-----------|--------------|-------------------|------------|----------|-----|
| GENERAL TOLERANCES | | | JOINT PROGRAM OFFICE FOR BIOLOGICAL DEFENSE | | | | | | |
| XX DECIMALS ±0.01 | XXX DECIMALS ±0.005 | ANGLES ±2.0 | | | | | | | |
| UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES REMOVE BURRS AND BREAK SHARP EDGES .015 MAX INSIDE CORNERS R .015 MAX SURFACE FINISH 125✓ | | | | | | SINGLE ASSAY TRAY | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| MATERIAL: | | CHECKED | | | SIZE | CAGE CODE | GIN | DWG NO. | REV |
| - | | DRAWN | CJI | 09-Nov-99 | D | 07609 | - | HHH-0004 | - |
| | | APPROVED FOR SAVSEA DATE | | | SCALE: 1.000 | WEIGHT: | SHEET 1 OF | | |
| DO NOT SCALE THIS DRAWING | | | | | | | | | |

| REVISIONS | | | |
|-----------|--|---------|----------|
| LTR | DESCRIPTION | DATE | APPROVAL |
| A | W WAS XR, XR WAS W, UC WAS AB, UL WAS UC, AB WAS UL | 4/28/03 | KHR |
| B | ADDED BOM & BALLOONS | 5/13/03 | KHR |

CAD MAINTAINED. CHANGES
SHALL BE INCORPORATED BY
THE DESIGN ACTIVITY



| | | | | | |
|----------|----------|-----------|--------------|---|------------------|
| 15 | 1 | | ZLL4108 | LABEL, HIGH SPEED LASER & COPIER 4-1/4 X 2-3/4" | |
| 14 | 1 | | BIDS-POUCH | POUCH, BIDS PANEL 5-11/16 X 10-3/4 W/ 1-1/8" TEARLINE | |
| 13 | 3 | | 02-02296CG02 | PACKET, .5 GRAM SILICA GEL MINIPAX WHITE, NO PRINTING | |
| 12 | 1 | | BW-106 | STRIP, "OS" TEST | |
| 11 | 1 | | BW-108 | STRIP, "AB" TEST | |
| 10 | 1 | | BW-107 | STRIP, "UL" TEST | |
| 9 | 1 | | BW-105 | STRIP, "UC" TEST | |
| 8 | 1 | | BW-104 | STRIP, "XR" TEST | |
| 7 | 1 | | BW-103 | STRIP "W" TEST | |
| 6 | 1 | | BW-102 | STRIP, "LE" TEST | |
| 5 | 1 | | BW-101 | STRIP, "N" TEST | |
| 4 | 8 | | ZLL4180 | LABEL, RETURN ADDRESS 1-11/16 X 11/16" | |
| 3 | 8 | | HHA-0003 | ASSAY, BACK PANEL | |
| 2 | 8 | | HHA-0002 | ASSAY, FRONT PANEL | |
| 1 | 1 | 07609 | HHA-0004 | CLAMP SHELL, SINGLE ASSAY TRAY | |
| FIND NO. | QTY REQD | CAGE CODE | PART NO. | NOMACLATURE OR DESCRIPTION | MATERIAL OR NOTE |

| | | | | | | | | | |
|--|--|--|--|--|-----------|---------|------------|--------------|--|
| PARTS LIST | | | | | | | | | |
| GENERAL TOLERANCES XX DECIMALS XXX DECIMALS ANGLES ±0.01 ±0.001 ±0.5 | | | | PROGRAM EXECUTIVE OFFICE FOR CHEMICAL & BIOLOGICAL DEFENSE (PEO-CBD) | | | | | |
| UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES REMOVE BURRS AND BREAK SHARP EDGES .015 MAX INSIDE CORNERS R .015 MAX SURFACE FINISH 125 | | | | OPERATIONAL PANEL ASSEMBLY | | | | | |
| MATERIAL: | | | | | | | | | |
| CHECKED | | | | SIZE | CAGE CODE | GIN | DWG NO. | REV | |
| DRAWN | | | | D | | - | HHA-JPO-10 | B | |
| APPROVED FOR | | | | DATE | | | | | |
| DO NOT SCALE THIS DRAWING | | | | SCALE: 0.750 | | WEIGHT: | | SHEET 1 OF 1 | |

Operational and Training Panel Manufacturing Instructions:

1. Each panel consists of inserting eight individual HHAs into a single assay tray. The specifications for the assay tray are provided in drawing number HHA-0004.
2. Manufacturing shall take place in a humidity and temperature controlled, 20 to 25 degrees Celsius, assembly room that can maintain less than 40% humidity with ASHRAE efficiency of 90-95% filtration.
3. Personnel shall wear gloves, lab coat, and full hair coverage apparel.
4. Snap each HHA assay into the assay tray using the appropriate coded configuration outlined in Table 1. Fold the cover over to secure them in place.

Table 1: Panel Configurations

| Configuration | Position | | | | | | | |
|-------------------|----------|-----|-----|-----|-----|-----|-----|-----|
| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 |
| Operational Panel | N | LE | W | XR | UC | UL | AB | OS |
| Training Panel | Pos | Neg | Neg | Neg | Neg | Neg | Neg | Neg |

5. Uncoded panels will be prepared in a configuration provided by the Government.
6. Package panel in accordance with steps A thru G, O1, O4, and P of Special Packaging Instructions (SPI) number PJPOHHA.
7. The sealed pouch shall also be marked with the following information:
 - a. panel name (Operational or Training)
 - b. lot number of each individual HHA
 - c. appropriate agent code and designation
 - d. date assembled
 - e. Special Marking: "NOT FOR DIAGNOSTIC USE".


Uncoded panels shall be labeled with agent name. The label shall also include the CRP and DoD insignias. A sample label for Operational and Training is provided in Figures 1 and 2 respectively.

8. Package and ship panels in accordance with commercial packaging or complete special packaging (SPI Number PJPOHHA) as directed on the Delivery Order.

9. The Contractor shall not implement engineering changes, or deviations which affect Government controlled documents (e.g. engineering drawings, SPI), without prior Government approval.

Figure 1

| Position | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 |
|------------------------|-------|-------|-------|-------|------|-------|-------|------|
| Type | N | LE | W | XR | UC | UL | AB | OS |
| Lot | 11201 | 11143 | 12071 | 12012 | 7243 | 12013 | 12073 | 8031 |
| Assembled | | | | 05/00 | | | | |
| NOT FOR DIAGNOSTIC USE | | | | | | | | |



CRP

Operational






Figure 2

| Position | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 |
|------------------------|------|------|------|-------|------|------|------|------|
| Type | POS | NEG | NEG | NEG | NEG | NEG | NEG | NEG |
| Lot | 6015 | 5161 | 5161 | 5161 | 5161 | 5161 | 5161 | 5161 |
| Assembled | | | | 05/00 | | | | |
| NOT FOR DIAGNOSTIC USE | | | | | | | | |



Training

NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)

| | | | | | | | |
|--|------------|--|--|---|-------------------------------|---|--------------------------------------|
| SPECIAL PACKAGING INSTRUCTION(SPI) (A) | | | | | | | NATIONAL STOCK NUMBER See Table 1 |
| NOMENCLATURE Hand Held Panel (See table 1) | | | | | UI BX(B) | QUP 10 (B) | SPI NUMBER (PN) PJPOHAA |
| Cleaning & Drying shall be in accordance with MIL-STD-2073-1 | | | | | | | |
| MILITARY PRESERVATION REQUIREMENT (MIL-STD-2073-1, Method 41) | STEPS | DRAWING OR SPECIFICATION | STYLE | TYPE | GRADE | CLASS | SIZE AND REMARKS (INCHES) |
| Container | 1 | MIL-DTL-117 | 1 or 2 | I | | E | 10 x 5 |
| Dessicant | (C) 2 | | | | | | 2.0 Units |
| Closure | (D)(E) 3 | | | | | | Heat Seal |
| Wrap | (F) 4 | A-A-59135 | | | A | 1 or 2 | 9 x 9 1/4 |
| Tape | (G) 5 | ASTM D 5486 | | V | | | As required |
| Container | (H) 6 | ASTM D 5118 | RSC | CF | W5c or V3c | WR | 13 3/4 x 10 1/2 x 6 1/2 ID |
| Closure | 7 | ASTM D 1974 | | | | | Sealing Method B |
| Bottom Pad | (I) 8 | | | | | | (see page 7) |
| Side Pad | (I) 9 | | | | | | (see page 9) |
| End Pad | (I) 10 | | | | | | (see page 10) |
| Top Pad | (J) (I) 11 | | | | | | (see page 8) |
| Container | (K) 12 | ASTM D 5118 | RSC | CF | W5c or V3c | WR | 18 3/8 x 15 1/8 x 11 1/4 |
| Closure | (L) 13 | ASTM D 1974 | | | | | Sealing Method B |
| Container | (M) 14 | ASTM D 6251 | A | III | | 2 | 18 3/4 x 15 1/2 x 11 7/8 ID |
| Closure | (N) 15 | ASTM D 6251 | | | | | |
| INTERMEDIATE PACKAGING AND PACKING <input checked="" type="checkbox"/> In accordance with MIL-STD-2073-1 <input type="checkbox"/> As specified hereon. | | | MARKING <input checked="" type="checkbox"/> In accordance with MIL-STD-129 and notes (O) and (P) <input type="checkbox"/> As specified hereon. | | | | |
| Unless otherwise specified, materials shall be minimum size in accordance with MIL-STD-2073-1. Tolerances shall be in accordance with material specifications. | | | | | | | |
| QUALITY PERFORMANCE and TESTING REQUIREMENTS <input type="checkbox"/> In accordance with MIL-STD-2073-1 <input checked="" type="checkbox"/> As specified hereon (Q) (R) (S) | | | | | | | |
| UNIT PACK LOGISTICS DATA (Approximate unit pack weight and size) | | | | | | | |
| WEIGHT (POUNDS) | | CUBE (CUBIC FEET) | | SIZE (EXTERIOR FEET) | | | |
| 3.86 lbs. | | 3.118 cu. ft. | | 1.75 x 1.51 x 1.18 | | | |
| TABLE 1 This SPI Provides packaging requirements for the following items | | | | | | | |
| Nomenclature | | Part Number | | | National Stock Number | | |
| Operational Hand Held Panel | | JPOHHA-10 | | | 6665-01-504-8534 | | |
| Training Hand Held Panel | | JPOHHA-20 | | | 6665-01-504-8535 | | |
| REMARKS/ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED. | | | | | | | |
| <p>(A) – This SPI is not applicable for Interplant shipments. Packaging and marking for interplant shipment is for supplies and materials that do not directly enter the military supply system. Typical interplant shipments are shipments from a vendor to a subcontractor or a prime contractor, or between contrac-</p> | | | | | | | |
| Original Preparer: Dean Hansen 7 Jan 2004 | | | | | Revised by: _____ Date: _____ | | |
| ITEM DATA (APPROX) ITEM CODE – _____ ITEM SIZE – 8 1/2 x 3 3/4 x 1 1/4 inches for one bagged Hand Held panel ITEM WEIGHT – .16 lbs. | | ECBC 81361 AMSRD-ECB-ENA-P PAGE NUMBER 1 NUMBER OF PAGES 13 | | <div style="border: 1px solid black; height: 40px; width: 100%;"></div> | | <div style="border: 1px solid black; height: 40px; width: 100%;"></div> | |
| | | | | DRAFT DEC 5 2005 | | | |
| | | | | APPROVAL | | REVISION | |
| | | | | DATE | | | |

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

2 of 13

SPI NUMBER (PN)

PJPOHHA

tors and subcontractors, or from a vendor or contractor to a military arsenal, plant, or other activity for evaluation, immediate use, or further processing as specified in the applicable contract.

- (B) –The unit of issue is Box. The quantity per unit pack container is 10 Hand Held Panels.
- (C) –Place the desiccant packs within the Barrier bag (step 1) . The desiccant shall be from Multisorb Technologies Inc. Product Name: MaxiPax. part number 02–00039AG03.
- (D) –Prior to closure of the barrier bag place Hand Held Panel into barrier bag.
- (E) –Closure of the barrier bag shall be accomplished by heat sealing. Heat sealing shall be accomplished in accordance with the barrier bag manufactures instructions. Excess air shall be removed from the barrier bag prior to heat sealing.
- (F) –As an alternate a foam pouch in accordance A–A– 59135, Grade A, class 1 or 2, size 13 x 5 1/2 inches with a 12 inch lip may be substituted. Roll the 12 inch lip around the foam pouch and secure with tape (see note D).
- (G) – Secure wrap (step 2) with specified tape as required.
- (H) –Place ten individually desiccated, bagged, cushioned and taped Hand Held Panels into the container.
- (I) –Material used for the cooler pack shall be 1.8 to 2.2 lbs density per cubic foot Polystyrene. The cooler pack shall be constructed in accordance with the sketches on pages 4 through 7 of this SPI. The R or thermal value of the material used for the cooler pack shall be not less than 4.3 R – Value per 1 inch thickness of material. The standard tolerance for material shall be (+ –) .09 inches. Suggested source of supply for the Polystyrene components of this pack is: FPM Expandable Polystyrene, 2053 Commerce Street, Lancaster, Ohio 43130, Phone number (740) 687–5934.
- (J) –Assemble the cooler pack from one Bottom Pad, Two Side Pads, and Two End Pads as shown on page 8 of this SPI. Then place the container containing the Hand Held Panels into the cooler pack as shown on page 9 of this SPI. Then place one Top Pad to affect the closure of the cooler pack.
- (K) –Place the assembled cooler pack inside the fiberboard container (step 12)(see page 9) of this SPI.
- (L) –**Level B exterior shipping container.** The fiberboard container (step 13) shall serve as the level B exterior shipping container when Level B exterior shipping containers are authorized. When using the Fiberboard container (step 13) as the Level B exterior shipping container the container step 14 and the closure step 15 is not required.
- (M) –**Level A exterior shipping container.** When Level A exterior shipping containers are required the wooden panel plywood box shall serve as the level A exterior shipping container. Place the outer most fiberboard container (step 13) in the wooden panel plywood box. The level A exterior shipping container shall be a Style A, Class 3, Type III, Treatment A, Wood–Cleated Panel board Box in accordance with ASTM D 6251 container. With an interior dimension of 18 3/4 x 15 1/2 x 11 7/8 inches.

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

3 of 13

SPI NUMBER (PN)

PJPOHHA

Oriented strand board shall not be used in the construction of the plywood container. Plywood cleats may be used in place of lumber cleats. If plywood cleats are used they shall be the same dimensions as required for the lumber cleats as specified in ASTM D 6251. When required fiberboard filler pads shall be applied to insure a tight fit of the packaging components. Fiberboard filler pads shall be Class WR, Variety SW, Grade W5c or V3c, Type CF in accordance with ASTM D 4727. Filler pads shall be applied between the fiberboard container and the inside of the plywood container when required to restrict movement of the cooler pack. Bottom and top pads shall be 18 x 15 inches. End pads shall be 18 x 11 inches. Side pads shall be 15 x 11 inches.

(N) – **Level A exterior shipping container closure.** Closure of the container shall be by nailing with 6 penny nails using the same nailing spacing as is required to assemble the panels of the box. In addition the Supplementary requirements of ASTM D 6251, strapping shall be applied. Strapping shall be Type 1, regular duty, Finish B, Grade 2 in accordance with ASTM D 3953. Width of strapping shall be at least 3/8 wide and at least .010 inches thick. Length of strapping shall be as required. Seals shall be Finish B, Regular Duty, Grade 2, Style I, III or IV. Size of seals shall be as required to match the strapping it is being used with. In lieu of the strapping requirements as specified in ASTM D 6251, two straps shall be used and be placed girth wise as shown on page 10 of this SPI.

(O) – In addition to the marking requirements of MIL–STD–129 the following marking shall be applied:

1. To the barrier bags step 3, the fiberboard containers step 7 of this SPI:

- a. Manufacture Date
- b. Expiration date
- c. Lot Number
- d. Shelf Life markings
- e. Special Marking:
“Protect From Freezing”

2. Special pack markings applied to the exterior shipping containers steps 13 and 15.

- a. Manufacture Date
- b. Expiration date
- c. Lot Number
- d. Shelf Life markings
- e. Special Marking:
“Protect From Freezing
Temperature Sensitive Material
Expedite Shipment and Movement
Apply Temperature Controls at Final Destination”

3. In additional special markings as shown in (2) e. above shall be marked in red print at least 48 print and placed on the marking side of the exterior shipping container. If there is not enough room on the marking side of the container. The label shall then be placed on top of the exterior shipping container.

4. In addition to the markings specified above, the Training Hand Held Panels shall be marked “**FOR TRAINING ONLY**” on the barrier bag (step 3), on all fiberboard containers and Exterior shipping containers. This special marking shall be placed in a conspicuous location on the identifi-

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

4 of 13

SPI NUMBER (PN)

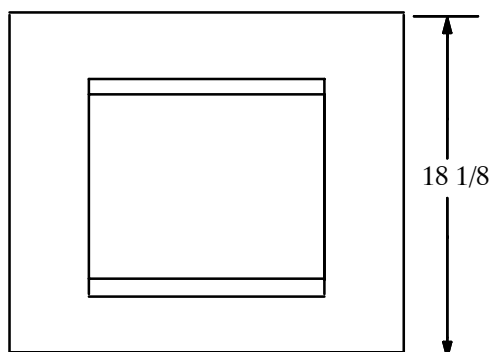
PJPOHHA

cation—marked side if the applicable container. This marking must be no less than $\frac{3}{8}$ of an inch in height.

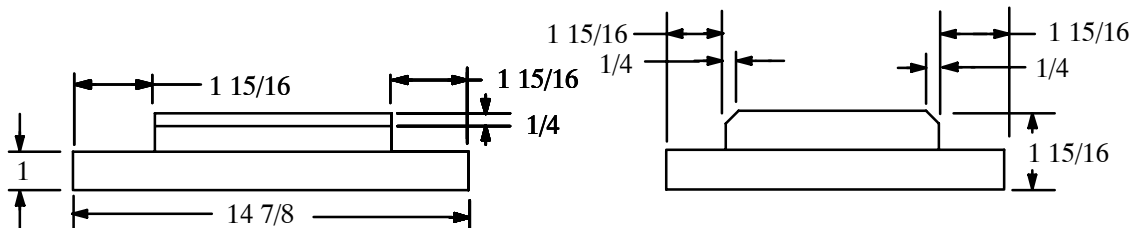
- (P) – In addition to the marking requirements found in note (O) apply one self adhering Temperature sensitive label on the marking surface of the barrier bag. Insure that the Temperature sensitive label does not cover any of the markings as required in note (O). The label shall be model, TL-S-140, manufactured by OMEGA Engineering Inc. P O Box 4047, Stamford, CT 06907-0047, Phone number 1-800-848-4286 or (203) 359-1660, Fax number (203) 359-7700. Web Site “www.omega.com”.

BOTTOM PAD

(1 Required)



DRAWING NOT TO SCALE
FOR REFERENCE ONLY



SPECIAL PACKAGING INSTRUCTION

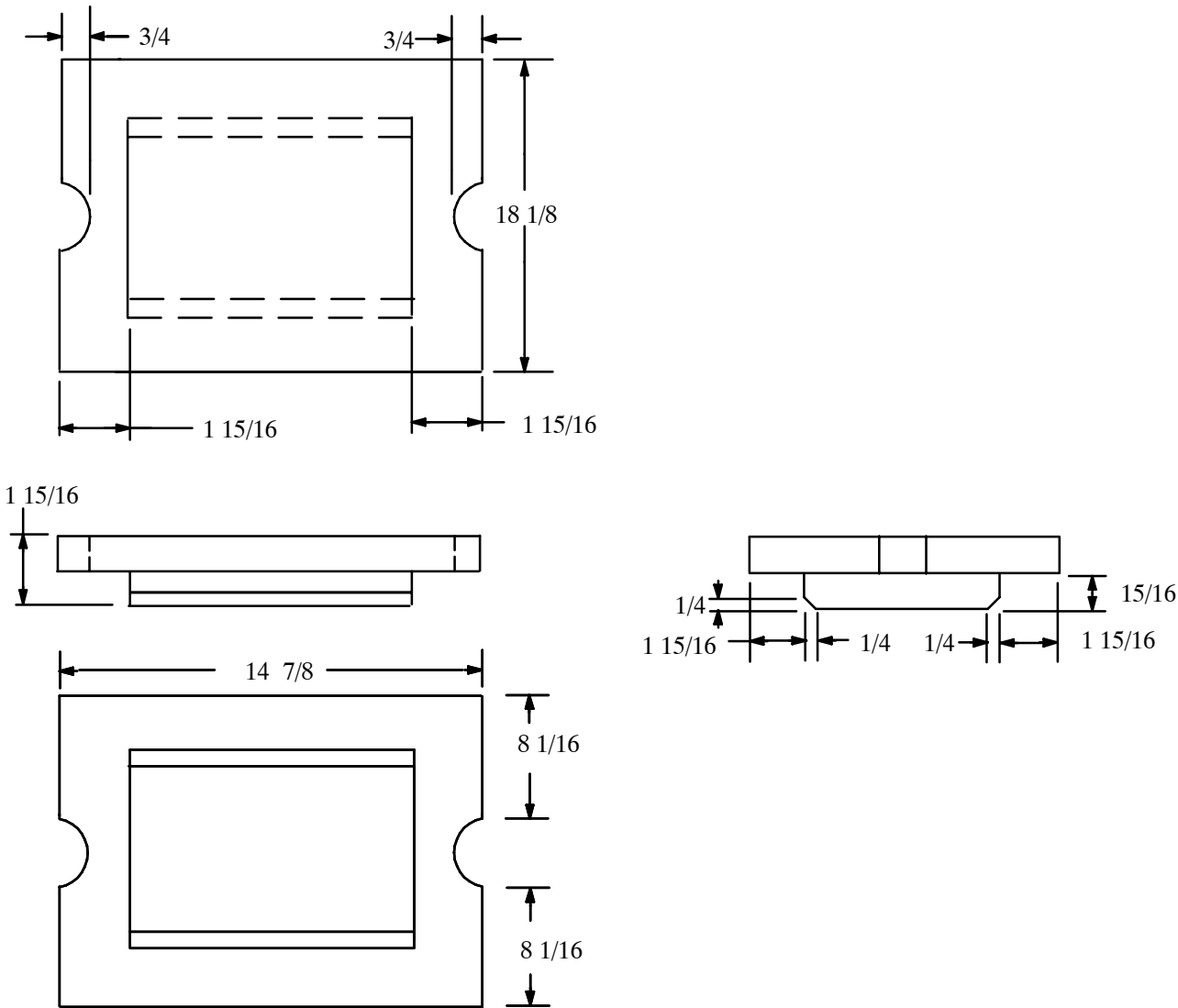
NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE
Hand Held Panel (see table 1)

PAGE NUMBER
5 of 13

SPI NUMBER (PN)
PJPOHHA

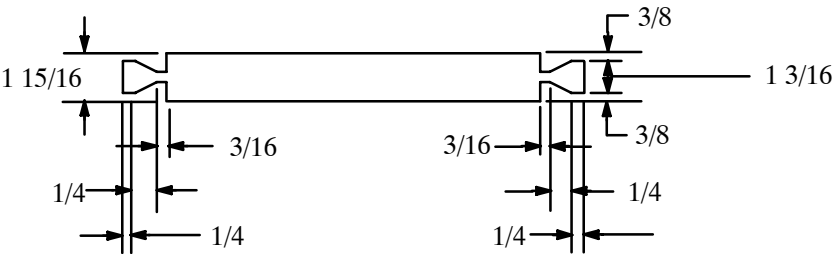
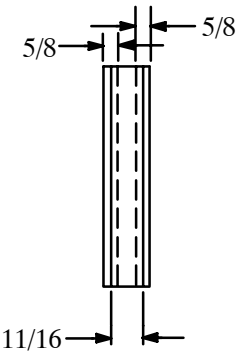
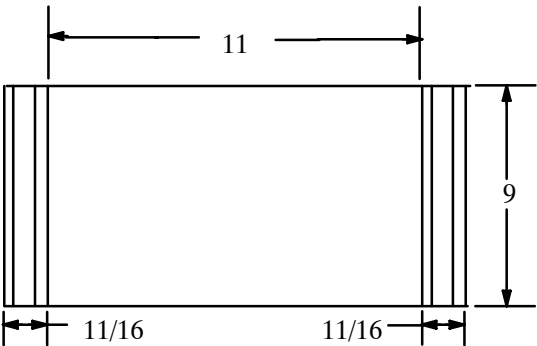
TOP PAD
(1 Required)



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

| | | | |
|---|--|--------------------------------------|----------------------------|
| SPECIAL PACKAGING INSTRUCTION | | NATIONAL STOCK NUMBER See Table 1 | |
| NOMENCLATURE Hand Held Panel (see table 1) | | PAGE NUMBER 6 of 13 | SPI NUMBER (PN) PJPOHHA |

SIDE PAD
(2 Required)



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

SPECIAL PACKAGING INSTRUCTION

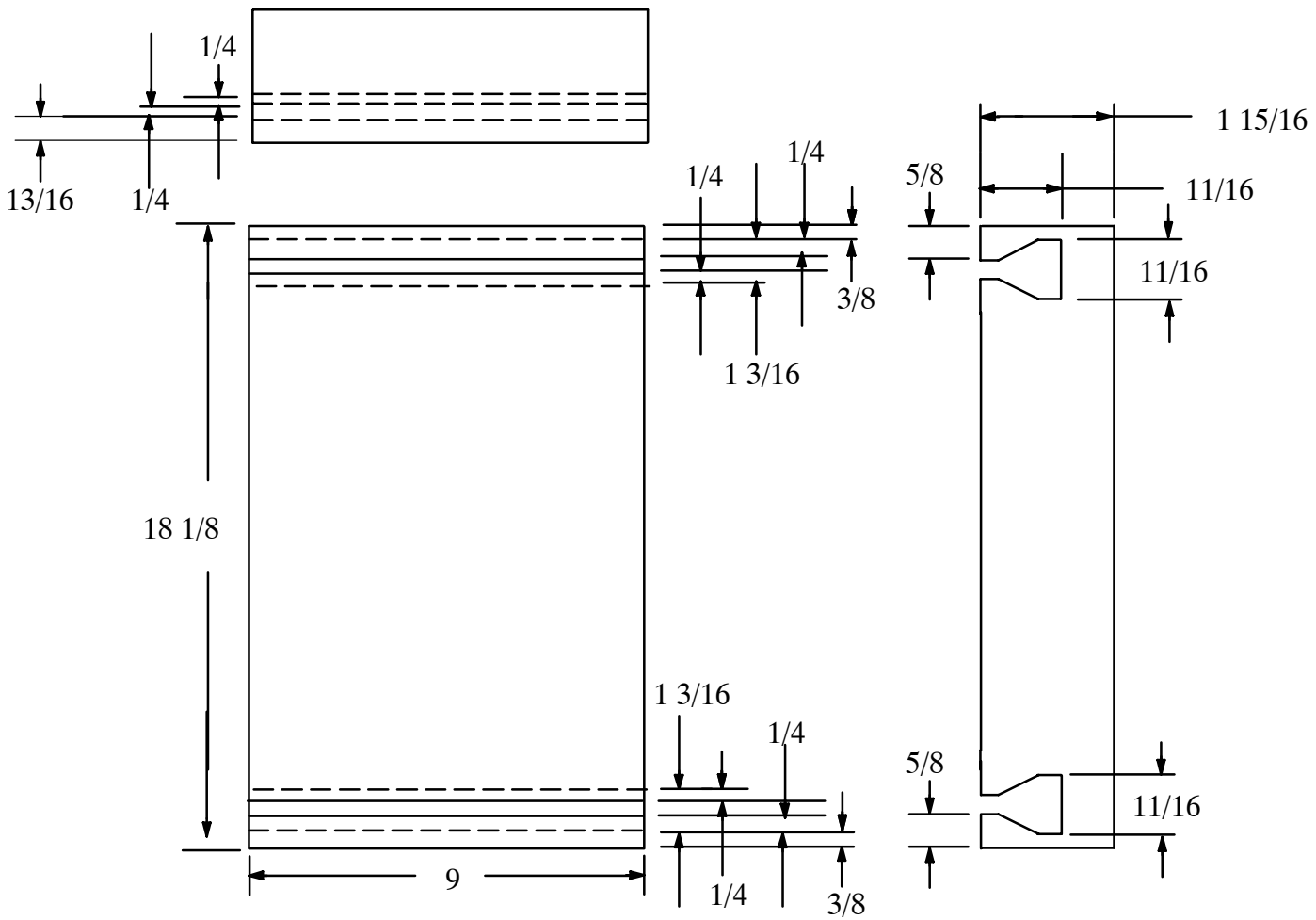
NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE
Hand Held Panel (see table 1)

PAGE NUMBER
7 of 13

SPI NUMBER (PN)
PJPOHHA

END PAD
(2 Required)



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

SPECIAL PACKAGING INSTRUCTION

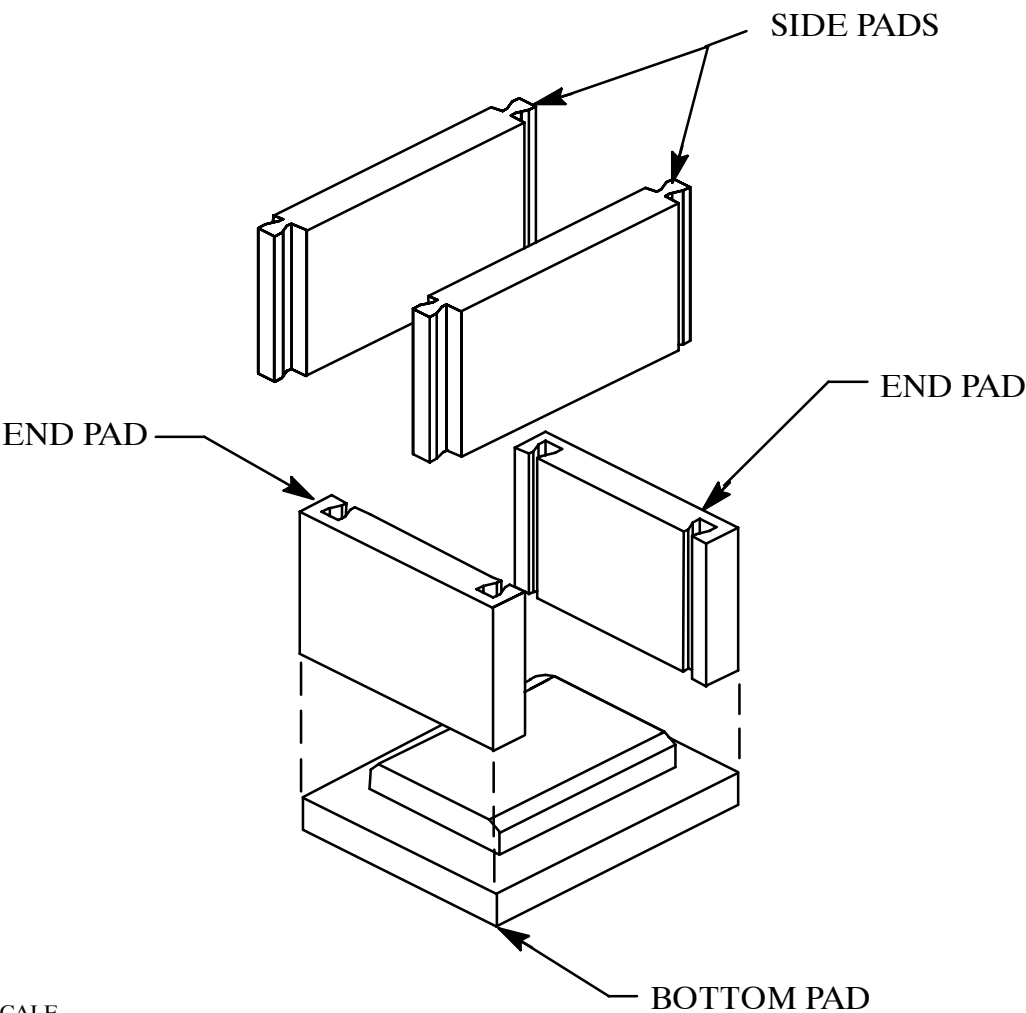
NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE
Hand Held Panel (see table 1)

PAGE NUMBER
8 of 13

SPI NUMBER (PN)
PJPOHHA

COOLER PACK ASSEMBLY



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

SPECIAL PACKAGING INSTRUCTION

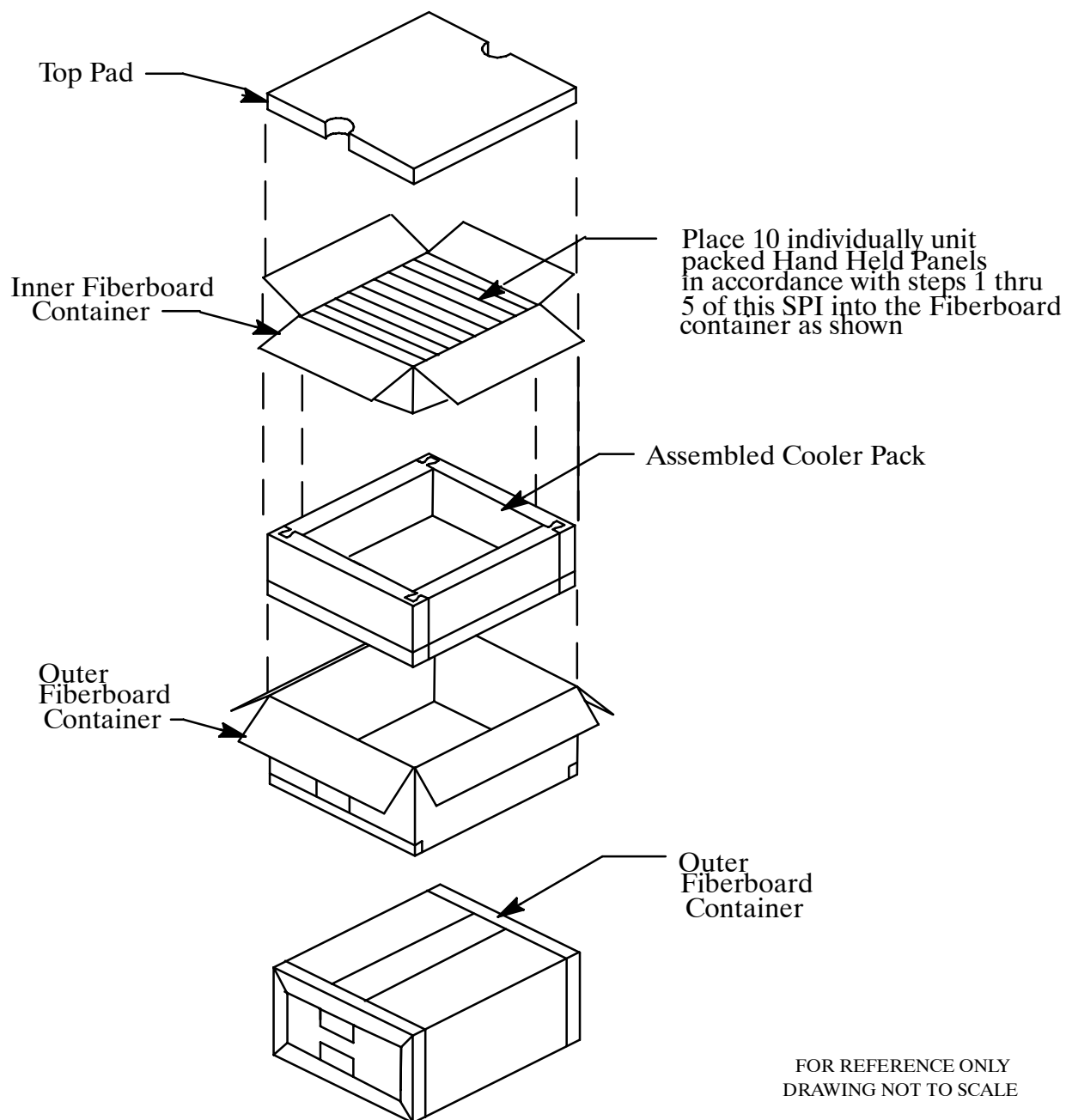
NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE
Hand Held Panel (see table 1)

PAGE NUMBER
9 of 13

SPI NUMBER (PN)
PJPOHHA

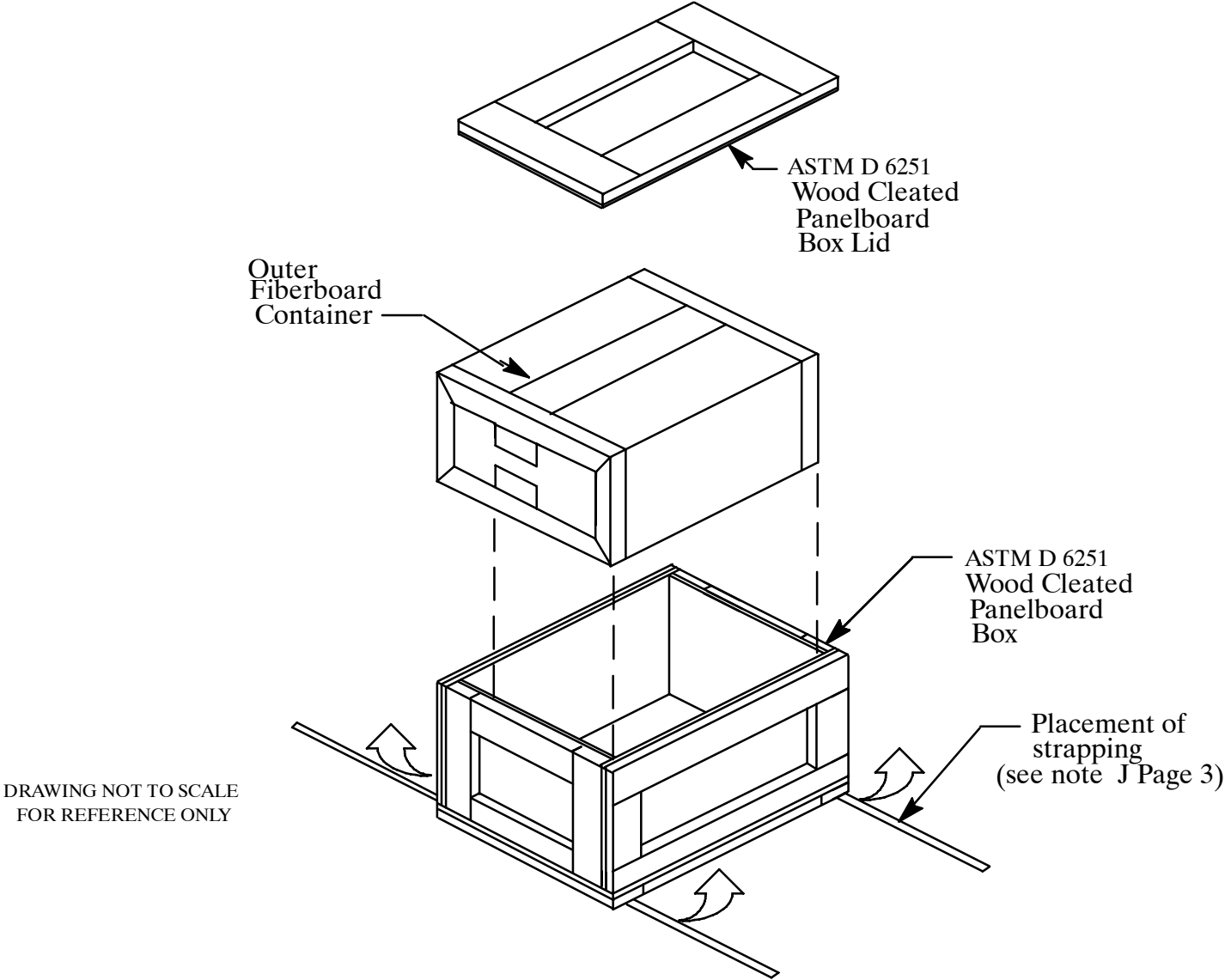
PLACEMENT OF ITEMS WITHIN CONTAINER



| | | | |
|---|--|--------------------------------------|----------------------------|
| SPECIAL PACKAGING INSTRUCTION | | NATIONAL STOCK NUMBER See Table 1 | |
| NOMENCLATURE Hand Held Panel (see table 1) | | PAGE NUMBER 10 of 13 | SPI NUMBER (PN) PJPOHHA |

LEVEL A EXTERIOR SHIPPING CONTAINER

(When Required)



NOTE:
CLOSURES OF CONTAINER NOT SHOWN

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

11 of 13

SPI NUMBER (PN)

PJPOHHA

- (Q) – **Hand Held Panel barrier bags leakage test.** The barrier bag (step 3 of the unit pack), containing the Hand Held Panel, shall show no sign of leakage as evidenced by a continuous stream of bubbles which appear at any surface when tested IAW the packaging quality assurance provision (PQAP) of this SPI.
- (R) – **Heat seal seam.** The heat seal seam of the Barrier Bag (step 3) shall show no sign of separation when tested in accordance with SPI.
- (S) – **PACKAGING QUALITY ASSURANCE PROVISIONS (PQAP)**

Part I – Applicable Documents

Military standards

MIL–STD–2073–1 – Standard Practice For Military Packaging

MIL–STD–1916 – Department Of Defense Test Method Standard

MIL–STD–3010 – Test Procedures for Packaging Materials

Part II – Quality Provisions.

1. First Article Inspection. The first article packaging sample shall be taken from the sample of Hand Held Panel JPOHHA–10 or JPOHHA–20 (as required) specified in the applicable contract and Specification for the item; however these samples shall be packaged as specified herein. The packaging Sample size for First Article Inspection shall be 3 packaged Hand Held Panels JPOHHA–10 or JPOHHA–20 (as required) and 3 empty barrier bags (step 3 of this SPI). These samples shall be subjected all of the inspections and examinations as specified in this PAQP. If required, special sampling, inspection and acceptance criteria are contained in Part III of this PQAP and inspected for compliance with any or all of the requirements of this SPI.

a. Acceptance Criteria. If any first article sample fails to comply with any of the requirements, the first article sample shall be rejected.

2. Conformance Inspection.

a. Sampling. Sampling shall be conducted in accordance with the attributes sampling plan of MIL–STD–1916 using the verification levels (VLs) specified herein. The packaged hand Held Panels shall be subjected to the following nondestructive inspections:

b. Inspection. Inspection shall consist of examination and test of all the characteristics contained in Part III of this PQAP.

3. Inspection equipment coding.

CE – Commercial inspection equipment

VI – Visual inspection

SPECIAL PACKAGING INSTRUCTIONNATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

12 of 13

SPI NUMBER (PN)

PJPOHHA

PART III – INSPECTION REQUIREMENTS
CLASSIFICATIONS OF CHARACTERISTICS

| <u>Category</u> | <u>Characteristic</u> | <u>Sampling and acceptance criteria</u> | <u>Inspection method</u> |
|------------------|--|---|--------------------------|
| <u>Critical:</u> | None Defined | | |
| <u>Major:</u> | None Defined | | |
| <u>Minor:</u> | | | |
| 101 | Item completely clean and dry prior to unit packaging | VL-II | VI |
| 102 | Barrier bag (step 1) evident and correct | VL-II | VI & CE |
| 103 | Desiccant (step 2) evident and correct | VL-II | VI & CE |
| 104 | Closure (step 3) evident and correct | VL-II | VI & CE |
| 105 | Wrap (step 4) evident and correct | VL-II | VI & CE |
| 106 | Tape (step 5) evident and correct | VL-II | VI & CE |
| 107 | Container (step 6) evident and correct | VL-II | VI & CE |
| 108 | Closure (step 7) evident and correct | VL-II | VI & CE |
| 109 | Bottom pad (step 8) evident and correct | VL-II | VI & CE |
| 110 | Side pad (step 9) evident and correct | VL-II | VI & CE |
| 111 | End pad (step 10) evident and correct | VL-II | VI & CE |
| 112 | Top pad (step 11) evident and correct | VL-II | VI & CE |
| 113 | Container (step 12) evident and correct | VL-II | VI & CE |
| 114 | Closure (step 13) evident and correct | VL-II | VI & CE |
| 115 | Container (step 14) evident and correct (when required) | VL-II | VI & CE |
| 116 | Filler pads (note M) evident and correct (when required) | VL-II | VI & CE |
| 117 | Closure (step 15) evident and correct (when required) | VL-II | VI & CE |
| 118 | Marking evident and correct | VL-II | VI & CE |
| 119 | Marking evident and correct | VL-II | VI |
| 120 | Temperature sensitive label evident and correct | VL-II | VI |

PART IV – CERTIFICATION REQUIREMENTS Certification shall be required for each characteristic specified below and shall include actual examination and test results when required herein. Results of examinations and tests shall be on file at the contractor's facility and shall be available to the Government for review.

| <u>NUMBER</u> | <u>Characteristic</u> | <u>To comply with</u> |
|---------------|-----------------------|---|
| 401 | Packaging material | Applicable specification or standard specified in this SPI. |

SPECIAL PACKAGING INSTRUCTION

NATIONAL STOCK NUMBER
See Table 1

NOMENCLATURE

Hand Held Panel (see table 1)

PAGE NUMBER

13 of 13

SPI NUMBER (PN)

PJPOHHA

PART V – TEST METHODS AND PROCEDURES

501 Unit pack assembly container leakage. The unit pack container (step 3 of the SPI) containing the Hand Held Panels shall not leak when tested in accordance with Test Method 5009 (Hot water Technique) of MIL–STD–3010.

As an alternate test. a Vacuum Pressure Desiccator Test may be substituted for Test Method 5009.

The following equipment is required:

One Vacuum pump with gage

One Vacuum Desiccator with stopcock valve.

Water

The procedure shall be as follows:

Fill the Vacuum Desiccator with 3 to 4 inches of water. Submerge barrier bags under water in the vacuum Desiccator. Place the lid on the chamber. Open the stopcock valve to the inward position. Turn on the vacuum pump. Observe the gauge to determine the integrity of the vacuum seal of the Desiccator. If the gage does not move re–seal lid until a vacuum pressure increase is observed. Allow the vacuum pressure to increase until the barrier bag inflates to approximately 1 inch overall from its original girth. Barrier bag should be inflated approximate 1 inch from its original girth. Observe the barrier bag for escaping bubbles which will indicate a leak. A rejection criterion will be if the barrier bags will not inflate as specified, seal integrity is compromised or if pin holes are observed. Criterion for a passed test shall be, none of the rejection criterion shall be noted, the barrier bags shall inflate as specified, the heat seal shall be show no sign of leakage and there shall be no visible pin holes.

502 Heat–seal seam strength. The heat seal seam of the empty barrier bags, step 3 of this SPI, shall be tested in accordance with Test Method 2024 (Heat Seal Seam Test) of MIL–STD–3010. No heat seal seam separation shall be noted during the test.